

Work Order ID 77324

December 2, 2011 1:14:11 PM

Page 1

Item ID: D3215-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Webbing Tidy

Start Date: 12/02/11 Start Qty: 60.00

60

Cust Item ID:

Required Date: 12/07/11 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan:

Date: 11/12/12 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3215	Rev D

100 FLOW WATER JET 0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3215 (D3215-3A)

Dwg Rev: D Prog

Rev: D 2-Deburr if necessary

3-Identify as D3215-3A

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3215-3 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 12/07/11 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab Memo 1-Cut D3215-3B (2.130" x 0.530") as per dwg D32152-Debur3-Identify as D3215-3B	0.00 0.00							<u>SP 11/12/06</u> (100)
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<u>SP 11/12/06</u> canted (100) -D3215-2's only
150 *150* Brake NC Brake NC	NC BRAKE Memo Form D3215-3A as per Dwg D3215	0.00 0.00							<u>SP 11/12/06</u> (94)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D3215-3 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 12/07/11 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>center</i> <i>(x94)</i>			<i>Pho →</i>
170 *170* Large Fab Large Fab	Large Fab Memo Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004A/R AL ROD BATCH: <i>M 114514</i> Identify as D3215- 3Grind flush	0.00 0.00						<i>JBL/EL</i> <i>11-12-12</i> <i>(x60)</i>	
180 *180* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00						<i>60</i> <i>8</i> <i>BE11-12-12</i>	

W/O: 77324

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3215-2 PAR #: _____ Fault Category: Small Fob NCR: Yes No DQA: AK Date: 11/12/14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 11/12/15

NCR: 11-1045

WORK ORDER NON-CONFORMANCE (NCR)

$$15.28 \times 6 = 91.68$$

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/07	130 120	Qty 46 Parts missing between QC 20 Small Fob Bending R.C. Lon when handling Parts	S 11/12/07 057042	→ cannot find missing Parts Parts there for scrap Qty 46.	SB 11/12/14	S 11/12/07	S 11/12/07 057042	S 11/12/07
		ONLY REC'D off						

NOTE: Date & initial all entries

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 Required Date: 12/07/11 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				counts x60			
200 *200* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
210 *210* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: FINISH TIME: OVEN TEMPERATURE:	0.00 0.00							

M115128

3:40
320°F 4:10

60x8 m-11/12/12

60x8 m-11/12/13

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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 Start Date: 12/02/11 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 12/07/11 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC3- Inspect Part Finish	0.00							
220									
QC	Memo	0.00							
Quality Control									
230		0.00							
230	Packaging								
Packaging	Memo	0.00							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

60X 11-12-14

CL 11/12/14 X60

11/12/14

CL 11/12/14

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Picklist Print

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Work Order ID: 77324

Parent Item: D3215-3

Parent Item Name: Webbing Tidy

Start Date: 12/02/11

Required Date: 12/07/11

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP A 04.01.06 New issue KJ/RF
IPP Rev:B Now on Waterjet 06-07-03 JLM
IPP rev C ecn 940 07.06.12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040 5052-H32 .040 Sheet		Purchased	No			100	sf	84.3000	0.008	0.5052632		12/11/12/06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		84.3							
				117130		5.8							
				119384		78.5							
M5052H32S.040 5052-H32 .040 Sheet		Purchased	No			130	sf	84.3000	0.0258	1.6294737		0.8 2.5 181-12-5	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		84.3							
				117130		5.8							
				119384		78.5							

119384

100

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

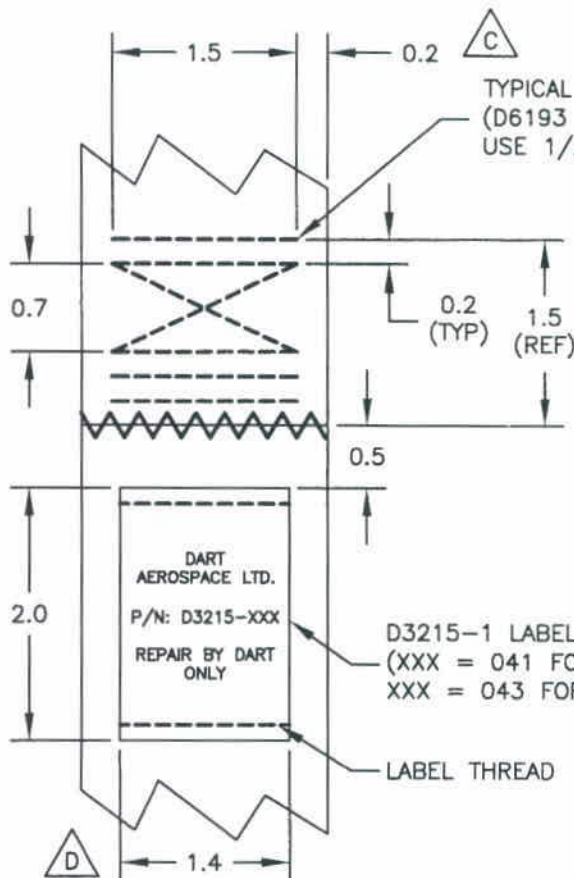
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

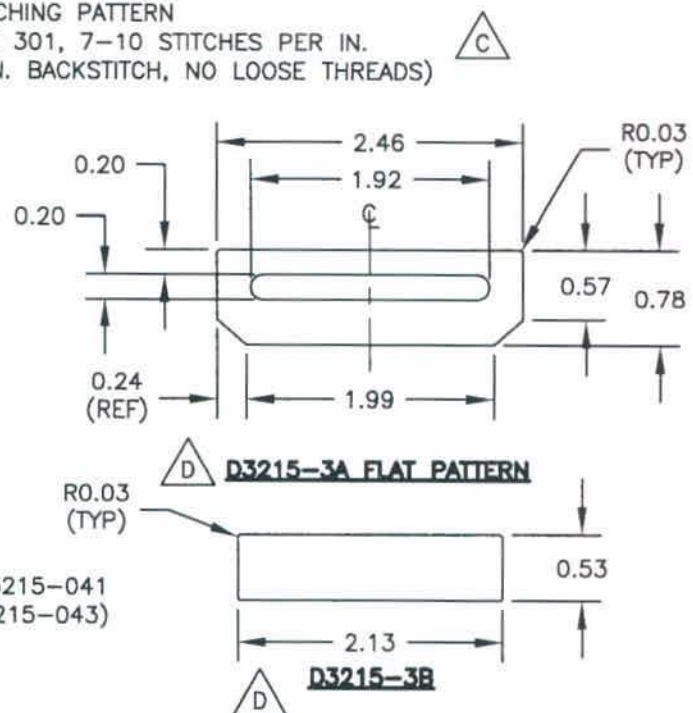
DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3215	REV. D SHEET 3 OF 3
DATE 07.03.27	TITLE HARNESS ASSEMBLY		SCALE 3:2

**VIEW A-A****D3215-1 LABEL:**

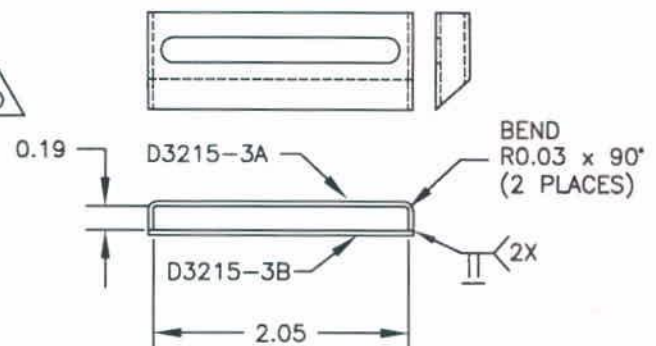
- 1) MATERIAL: WHITE TYVEK OR WHITE POLYESTER WHICH MEETS FMVSS 302
- 2) USE 1/8 BLACK LETTERING
- 3) CENTER ON BELT WIDTH

RELEASED07.06.07 *[Signature]***GENERAL NOTES:**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

**D3215-3A/-3B NOTES:**

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC. M5052H32S.040)
- 2) BEND D3215-3A PER D3215-3

**D3215-3 WEBBING TIDY****D3215-3 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

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